

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014615**Date Inspected:** 02-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu shi gao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

**OUTSIDE SHOP****11BW**

SMAW welding of weld joint 3G-009 located on PCMK SEG067D of Segment 11BW welder is identified as 054013. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appeared to Comply with the WPS-B-T-4213-Tc-U4b-2.

SMAW welding of weld joint 4F-029 located on PCMK SEG067D of Segment 11BW welder is identified as 043661. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2114.

SMAW welding of weld joint 3F-030 located on PCMK CA83 of Segment 11BW welder is identified as 204339. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appeared to Comply with the WPS-B-T-4113-2.

SMAW welding of weld joint 3F-054 located on PCMK CA81 of Segment 11AE welder is identified as 215553. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appeared to Comply with the WPS-B-T-4113-2.

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## 11EW

SMAW welding of weld joint 3F-129 located on PCMK SSD13-PP106 of Segment 11EW welder is identified as 047864. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2114-FCM-1.

SMAW welding of weld joint 4G-132 located on PCMK SSD13-PP106 of Segment 11EW welder is identified as 047864. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

During in process visual inspection it is found that fillet weld joint fit-up is identified as SSD13A-PP107-129/130. The root gap of this joint exceeds 5mm. This is informed to ZPMC QC Mr. Li ping and ABF QA Mr. Liu jin ping to get Engineer approval before welding.

## 11DW

SMAW welding of weld joint 1G-127 located on PCMK SSD10-PP104 of Segment 11DW welder is identified as 067764. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2211-B-U2-FCM-1.

SMAW welding of weld joint 4G-197 located on PCMK SSD10-PP104 of Segment 11DW welder is identified as 049339. ZPMC QC is identified as Mr. Wushi gao. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-B-U2-FCM-1

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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## Summary of Conversations:

No relevant Conversation.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Chadra	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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